

Work Order ID 83054

April-12-12 1:28:16 PM

83054

Page 1

Item ID: D4034-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Upper Rib Assembly

Start Date: 12/04/2012 Start Qty: 3.00

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4034 | B | | | | | | | | |

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

100

Large Fab

Memo 0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564 ✓

2- Weld bushing in rib and grind weld flush as per dwg ✓

4 0 SL 12.04.30

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo 0.00

Quality Control

4A 0 SL 12.04.30

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

Sizkster

(x6)

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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83054

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N900040100

Setup Start ***NS1***

Stop ***NS2***

3

3

Reference:

Run Start *NR1*

Stop *NR2*

Date:

Date:

**Insp.
Stamp**

0.00

0.00

Memo

0.00

0.00

Quality Control

12/5/12
MF
12-05-01

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Picklist Print

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Page 1

Work Order ID: 83054

83054

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 12/04/2012

Required Date: 18/04/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS PER

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| ✓ D4034-1 *D4034-1* Rib | | Manufactured | No | | | 100 | Each | 36.0000 | 1 | 3 | | 12.04.30 | ** |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA006 | | 36 | | | | | | | |
| | | | | 82259 | | 6 | | | | | | | |
| ✓ D4034-3 *D4034-3* Rib | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 3 | | 12.04.30 | ** |
| ✓ D4021-7 *D4021-7* Hoop | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 3 | | 12.04.30 | ** |
| * D4021-9 *D4021-9* Bushing | | Manufactured | No | | | 100 | Each | 10.0000 | 4 | 12 | | 12.04.30 | ** |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA005 | | 10 | | | | | | | |
| | | | | 66437 | | 2 | | | | | | | |
| | | | | 70333 | | 4 | | | | | | | |
| | | | | 72482 | | 4 | | | | | | | |

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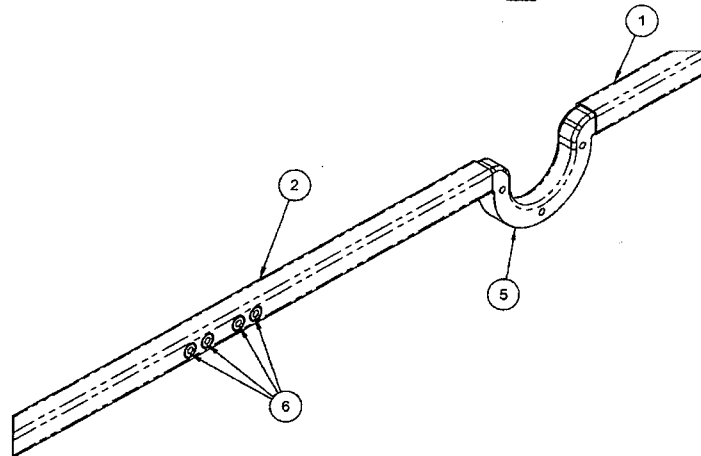
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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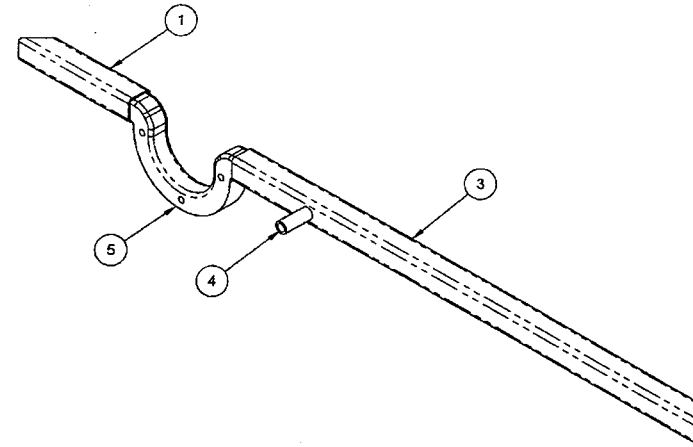
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| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83054 MLJ
12/04/12

RELEASED
R 2011-01-18
MB

| | | | |
|------------|---------------------------------------|--|--------------|
| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | MB | D4034 | SHEET 1 OF 4 |
| APPROVED | MB | TITLE | SCALE |
| DE APPR. | MB | UPPER RIB ASSY, BASKET BASE | NTS |
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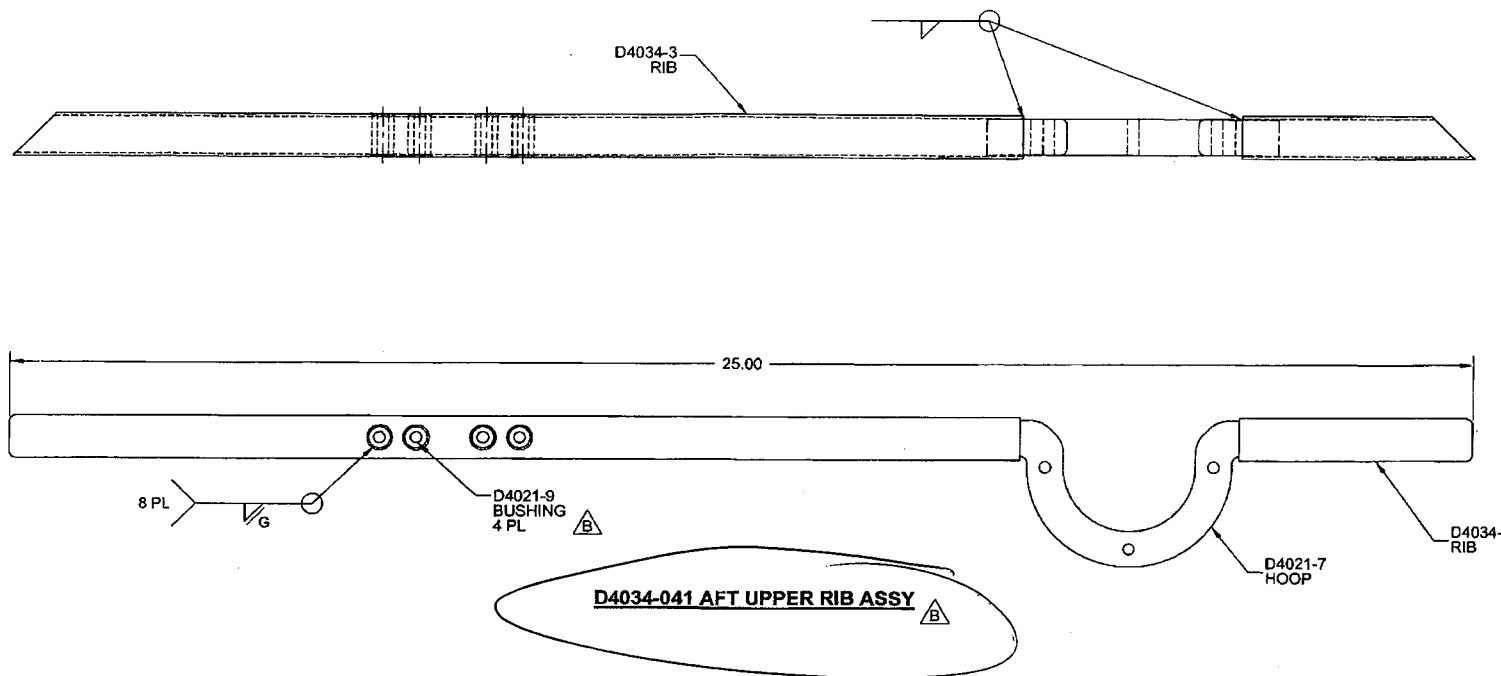
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

83054



RELEASED
2011-01-28

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

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| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | JS | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D4034 | SHEET 2 OF 4 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | UPPER RIB ASSY, BASKET BASE | NTS |
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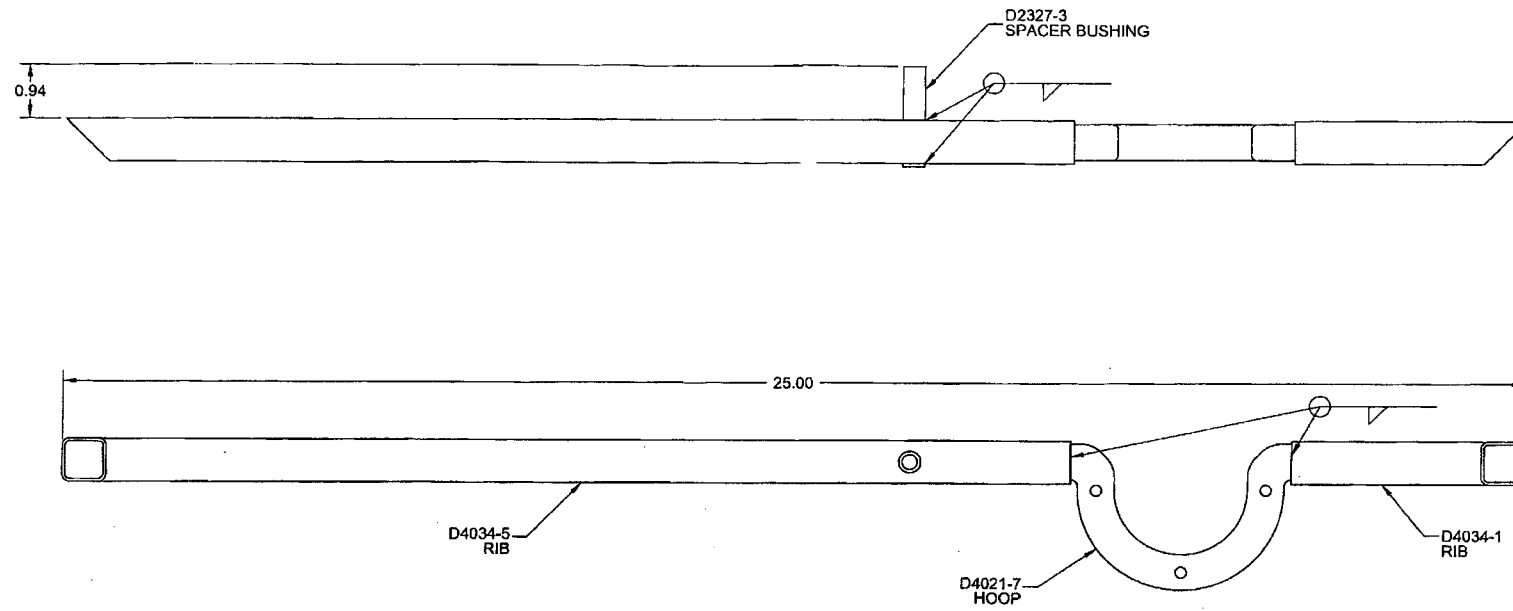
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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D4034-043 FWD UPPER RIB ASSY

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R 2011-01-18 JMD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

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| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | h | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4034 | SHEET 3 OF 4 |
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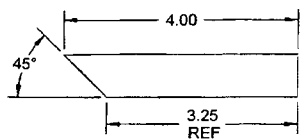
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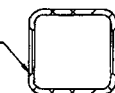
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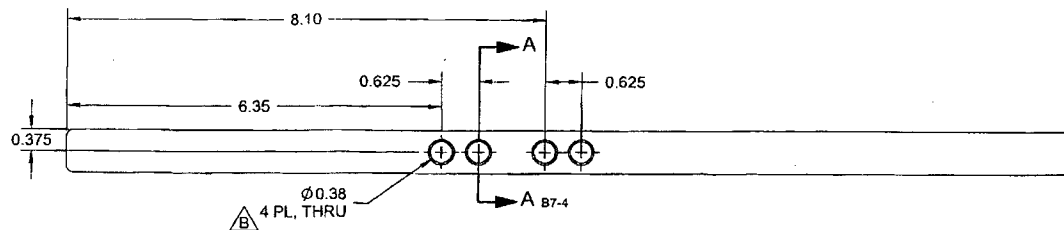


D4034-1 RIB

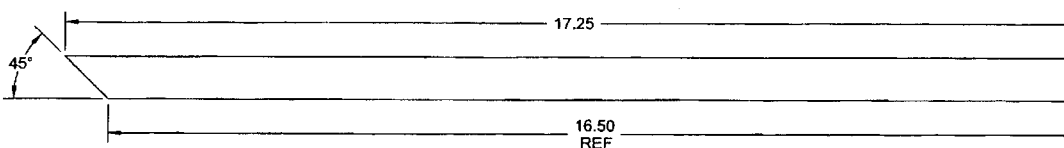
BREAK EDGE
0.030 X 45°
TYP



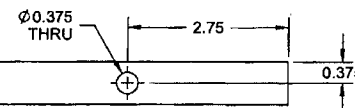
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

| | | | |
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| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| CHECKED | K | DRAWING NO. D4034 | REV. B |
| MFG. APPR. | [Signature] | SHEET 4 OF 4 | |
| APPROVED | [Signature] | TITLE | SCALE |
| DE APPR. | [Signature] | UPPER RIB ASSY, BASKET BASE | |
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2011-01-10
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